

Date: Thursday, 28/05/2009 9:13:26 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET QUICK REALEASE 350/355
Job Number :	48263		
Estimate Number :	10241		
P.O. Number :		Part Number :	DSI 9052011
This Issue :	28/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	DSI 9052 REV D
First Issue :	1 /	Project Number :	N/A
Previous Run :	46602	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	JUD 09.05.28	Due Date :	04/06/2009
Comment :	Est Rev:A 02.05.15 New Issue NG	Qty:	5
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 9052-011 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	BLRS010	Pip Pin
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 BLRS-010

Quick Release Pin (1" grip)

M111253

M111774

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D9052-011

Location: N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET QUICK REALEASE 350/355

Job Number: 48263

Part Number: DSI 9052011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 9.06.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9052	REV. D SHEET 1 OF 1
DATE 04.03.23		TITLE QUICK PIN REPLACEMENT	SCALE NTS
A	96.11.04	NEW ISSUE	
B	96.11.13	ADD PART NUMBERS	
C	03.12.11	ADD DSI 9052-013	
D	04.03.23	ADD CLAMPS ONLY NOTE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F
(REF. CANADIAN STC: SH94-14, REF. FAA STC: SR00213NY)
AND TO AMEND INSTALLATION DRAWING D350-602 REV. D
(REF. CANADIAN STC: SH93-97, REF. FAA STC: SR01144NY)

PURPOSE: TO ALLOW SUBSTITUTION OF THE BASKET/POD ATTACHMENT BOLTS WITH QUICK RELEASE PINS

THE AN4-12A & AN4-16A BOLTS USED ON D2230-1 CLAMPS MAY BE REPLACED WITH STAINLESS STEEL POSITIVE LOCKING QUICK RELEASE PINS WITH A MINIMUM DOUBLE SHEAR STRENGTH OF 2400 LBS AND 0.25 INCH DIAMETER.

BOLT	MIN GRIP	POSSIBLE QUICK RELEASE PIN REPLACEMENT
AN4-12A	1.0"	AVIBANK: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S MS NUMBER: MS17984C410, MS17985C410, MS17986C410, MS17987C410 REID: BLRS-010, BLBS-010
AN4-16A	1.3"	AVIBANK: BLC4B13S, BLC4TA13S, BLC4R13S, BLC4LA13S MS NUMBER: MS17984C413, MS17985C413, MS17986C413, MS17987C413 REID: BLRS-020, BLBS-020

THE FOLLOWING OPTIONAL KITS ARE AVAILABLE FROM DART TO PROVIDE QUICK RELEASE CAPABILITY:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9052-011	QUICK RELEASE KIT, FOR D350-607-041/-043/-045/-047
	X	DSI 9052-013	QUICK RELEASE KIT, FOR D350-602-011
4	1	BLRS-010	QUICK RELEASE PIN (1" GRIP)
	3	BLRS-020	QUICK RELEASE PIN (1.5" GRIP)

IT IS ACCEPTABLE TO LEAVE THE D2230-1/-3 CLAMPS INSTALLED ON THE CROSSTUBES WHEN THE BASKET OR POD IS REMOVED.

WEIGHT & BALANCE, FOR CLAMPS ONLY, IS 1.8lb (0.82kg) @ STA 135in (3.43m) & BL ±36in (±0.91m).

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 48263

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE: 04.03.23	
CERT. NO.: SH94-14	
ISSUE NO.: 4	

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE: 04.03.23	
CERT. NO.: SH93-97	
ISSUE NO.: 3	

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